



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-021
Job Sheet 194007



Part No: D350-636-021

Job Qty: 1 pcs

Part Name: AS350/355 - Skidtubes - Standard w/ Standard Wearplates - LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/24/19

Job Tracking No:

Due Date: 6/5/19

Created By: Jennifer Renwick

Type: Stock

Description: SIOP

Note: D2750-051 REV.H / IIN-D350-636 REV.K IPP REV:A 18.11.23 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter / Supplier	Lead Time	
90	Skidtubes - 1	1 pcs		6/5/19	0.00	4.55	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		BE
							Skidtubes - 6		
							Skidtubes - 7		
110	Skidtubes - 2 - B4B	1 pcs		6/5/19	0.00	4.55	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		BE
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
120	QC 10	1 pcs		6/5/19	0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs		6/5/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
140	Handfinish - 1-1 Chemical-B4B	1 pcs		6/5/19	0.00	0.93	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		

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				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R. 19/05/06
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	QC 7	1 pcs	6/5/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
160	Skidtubes - 3 - B4B	1 pcs	6/5/19	0.00 4.55	Skidtubes - 1 - B4B
					Skidtubes - 2 - B4B
					Skidtubes - 3 - B4B
					Skidtubes - 4 - B4B
					Skidtubes - 5 - B4B
					Skidtubes - 6 - B4B
					Skidtubes - 7 - B4B
170	QC 10	1 pcs	6/5/19	0.00 0.00	QC 10 - 10
					QC 10 - 18
					QC 10 - 24
					QC 10 - 43
					QC 10 - 50
					QC 10 - 58
					QC 10 - 9
180	QC 5	1 pcs	6/5/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58

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MAY 16 2019
68
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				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	6/5/19	0.00 0.93	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	✗ MAY 22 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
200 Spray Paint - 2 - B4B	1 pcs	6/5/19	0.00 0.91	Spray Paint - 1 - B4B	AR 19-5-23
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
				Spray Paint - MJ1 - B4B	
				Spray Paint - MJ2 - B4B	
				Spray Paint - MJ3 - B4B	
				Spray Paint - MJ4 - B4B	
205 Outsource - 10 - Consignment	1 pcs	6/5/19		ATE003-VC	5 NR
210 QC 14	1 pcs	6/5/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	BEB 19-05-24
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
230 Handfinish - 4-1-Assembly- B4B	1 pcs	6/5/19	0.00 0.93	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
240 QC 5	1 pcs	6/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS 19 9-89
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	6/5/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	

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DAS
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**DAS
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9-89**

Job BOM

M. A. 009970

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Skidtubes - 1	D2600-3-BENT-LH	1	7	0
110-Skidtubes - 2 - B4B	D2744	1	17	0
160-Skidtubes - 3 - B4B	D2739	1	9	0
	D2743	8	143	0
230-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	38	1,681	0
	AN3C34A	1	12	0
	AN3C5A	34	1,547	0
	AN3C6A	4	317	0
	AN6C44A	4	132	0
	AN8C35A	1	62	0
	D2745	8	168	0
	D3488-3	1	3	0
	D3537-1	3	80	0
	D3631-1	8	197	0
	D3791-1	1	3	0
	D3793-1	1	5	0
	D3793-3	1	2	0
	D3793-5	1	15	0
	MS21043-3	1	1,018	0
	MS21043-6	4	154	0
	MS21083C8	1	210	0
	NAS1149C0332R	38	5,802	0
	NAS1149C0363R	2	437	0
	NAS1149C0832R	1	340	0
	NAS1515H3L	4	358	0
250-Packaging 1-1 - Pick Kit - B4B	AN8C21A	2	85	0
	D2741	1	63	0
	MS21083C8	2	210	0
	NAS1149D0863J	2	465	0
Part Specifications				
Specifications could not be found.				

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QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X					D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X				D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X			D2750-044	350 SKIDTUBE ASSEMBLY, RH
				X		D2750-051	350 SKIDTUBE ASSEMBLY, LH
					X	D2750-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1						D2750-1	350 SKIDTUBE ASSEMBLY
	1					D2750-2	350 SKIDTUBE ASSEMBLY
		1				D2750-3	350 SKIDTUBE ASSEMBLY
			1			D2750-4	350 SKIDTUBE ASSEMBLY
				1		D2750-5	350 SKIDTUBE ASSEMBLY
					1	D2750-6	350 SKIDTUBE ASSEMBLY
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG
8	8					D3492-043	PLUG
		8	8			D3492-045	PLUG
3	3	3	3	3	3	D3537-1	WEARPAD
8	8	8	8	8	8	D3631-1	WASHER
1	1	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	1	1	D3793-5	WEARSHOE
38	38	38	38	38	38	ALS4-1032-225	INSERT
				1	1	AN3C34A	BOLT
34	34	34	34	34	34	AN3C5A	BOLT
4	4	4	4	4	4	AN3C6A	BOLT
4	4	4	4	4	4	AN6C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
				1	1	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
38	38	38	38	38	38	NAS1149C0332R	WASHER
				2	2	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.1 lbs
D2750-051/-052 = 25.7 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 19/64" SIZE HOLES (ϕ 0.297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

H	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D2750-5/-6 (ZN C5-1 SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11/-12/-13/-14); D3793-5 REPLACES D3535-25 (ZN B6-1, C4-11/-12/-13/-14); NAS1149C0332R REPLACES AN860C10L (ZN A5-1, B1-11/-12/-13/-14, C7-11/-12/-13/-14); NAS1149C0832R REPLACES AN960C816L (ZN A5-1, C1-11/-12/-13/-14); REMOVED D3794-1/-3, AND D3536-25 GASKETS	ZF	18.03.05
G	CORRECTED TOLERANCE ON ϕ 0.500 THRU HOLE: IS +0.01/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1/-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A5-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 1 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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2018 OCT 19
Z.N.18.530

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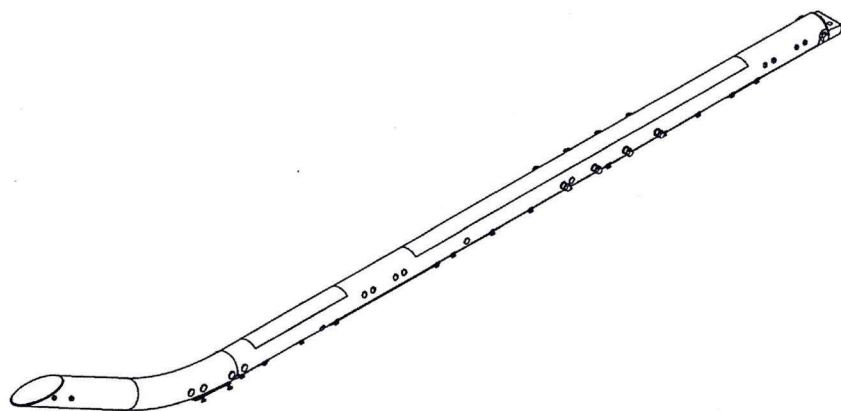
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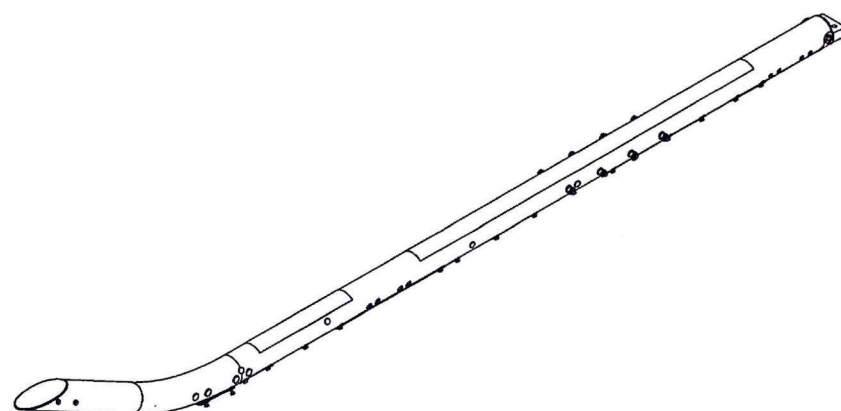
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B

A



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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APPROVED	NO	TITLE	SCALE
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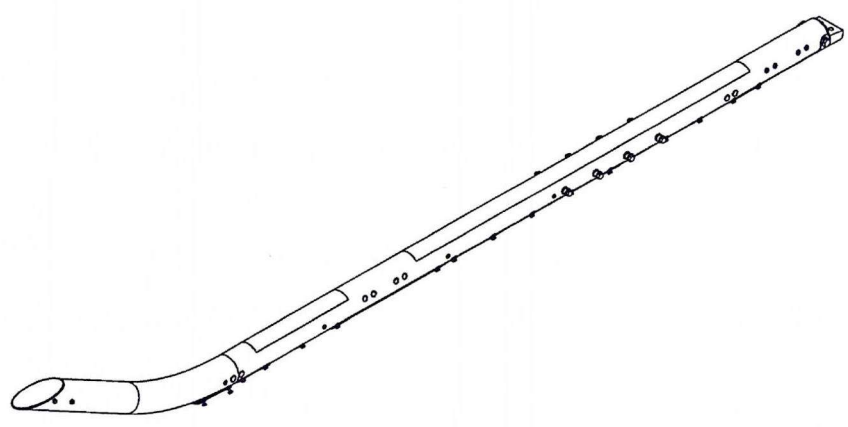
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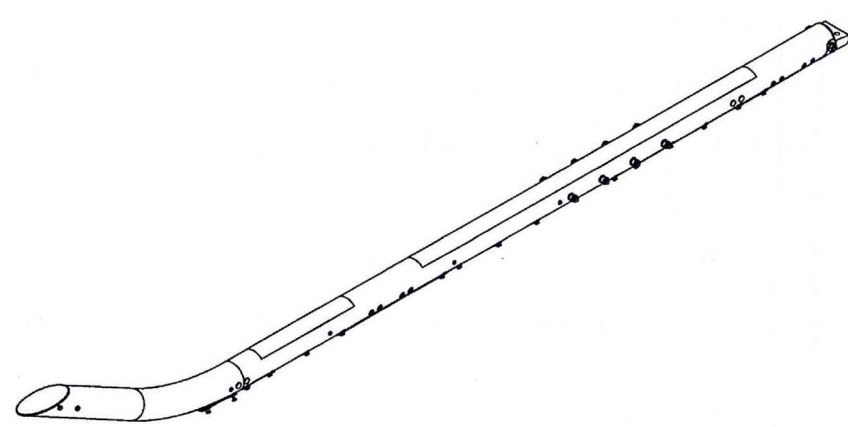
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A



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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2018 OCT 19

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APPROVED	NO	TITLE	SCALE
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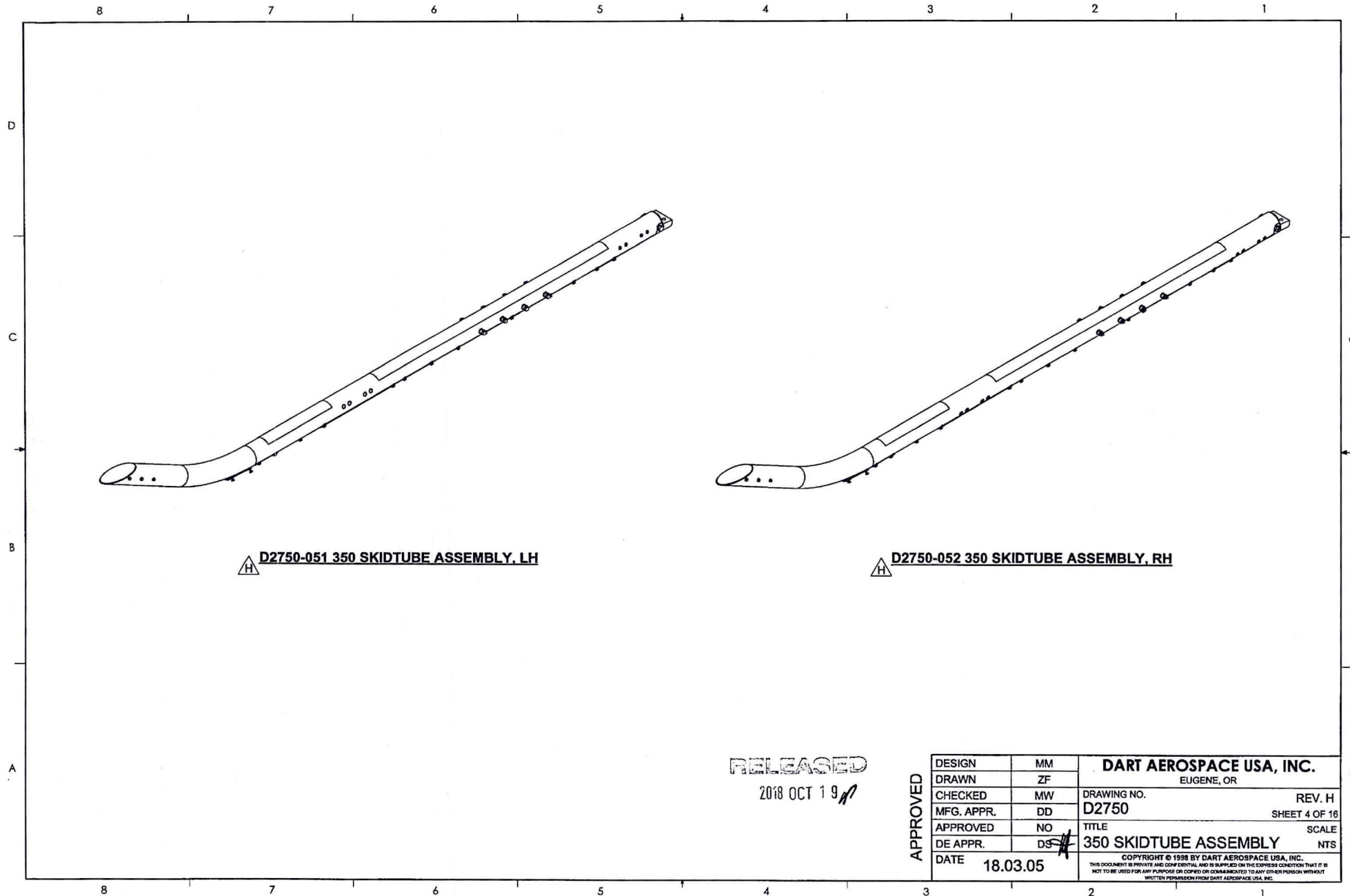
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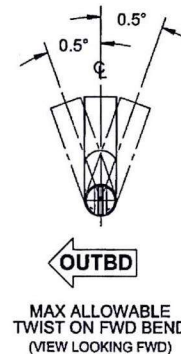
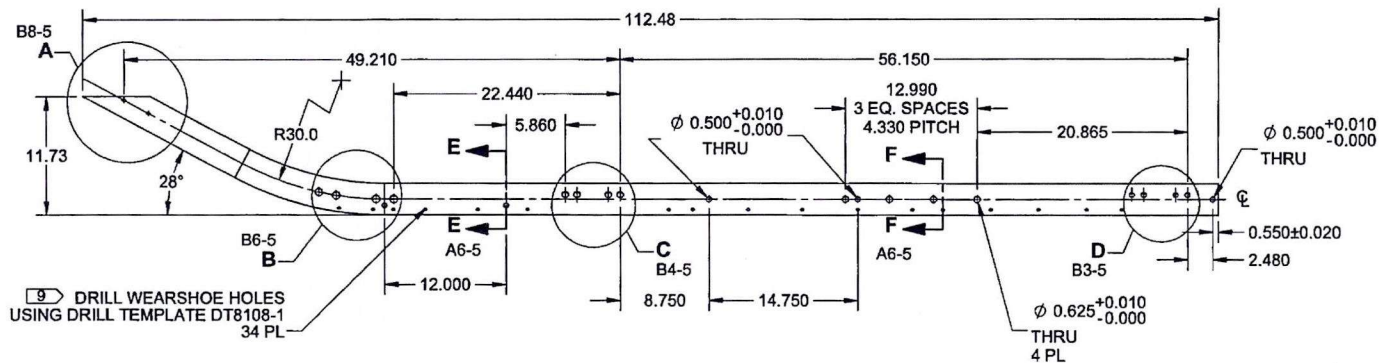
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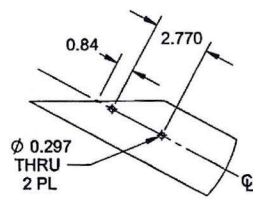
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A

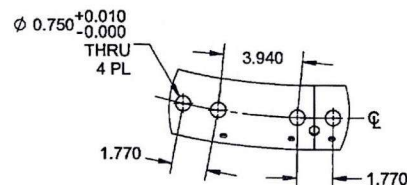




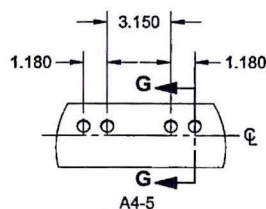
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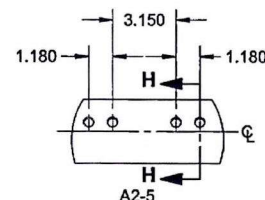
D7-5
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SCALE 2X



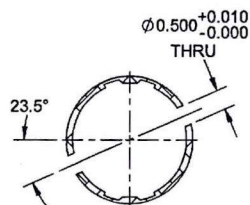
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DETAIL B
SCALE 2X



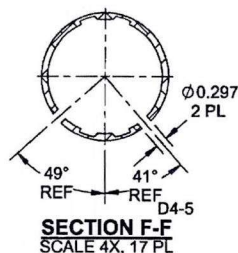
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DETAIL C
SCALE 2X



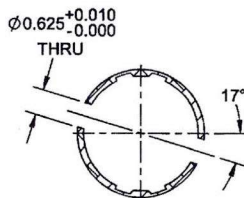
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DETAIL D
SCALE 2X



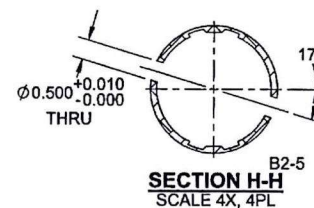
D5-5
SECTION E-E
SCALE 4X, 2 PL



SECTION F-F
SCALE 4X, 17 PL



SECTION G-G
SCALE 4X, 4 PL



SECTION H-H
SCALE 4X, 4 PL

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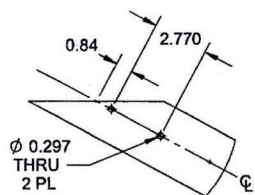
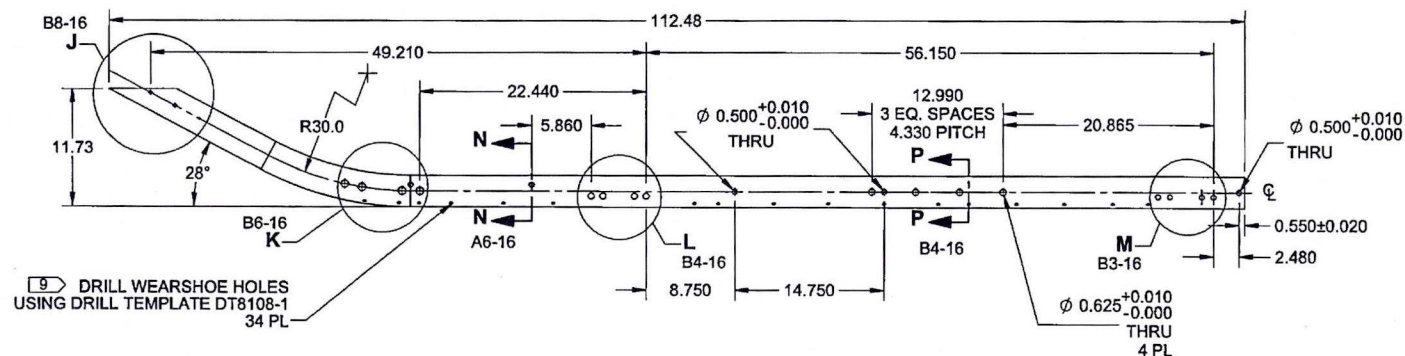
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DATE	18.03.05

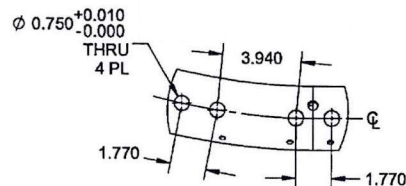
DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO.
D2750
REV. H
SHEET 5 OF 16
TITLE
350 SKIDTUBE ASSEMBLY
SCALE
NTS

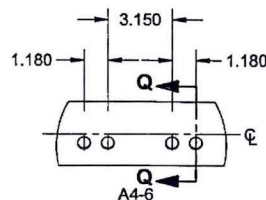
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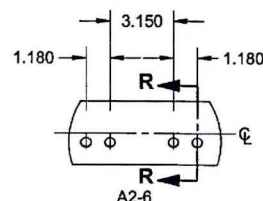
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SCALE 2X



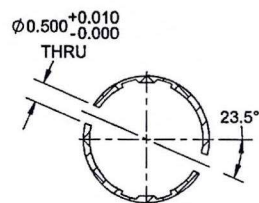
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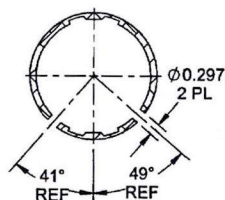
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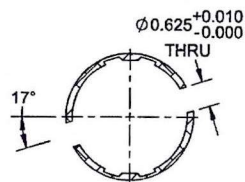
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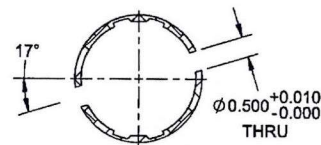
D6-6
SECTION N-N
SCALE 4X, 2 PL



D4-6
SECTION P-P
SCALE 4X, 17 PL



B4-6
SECTION Q-Q
SCALE 4X, 4 PL

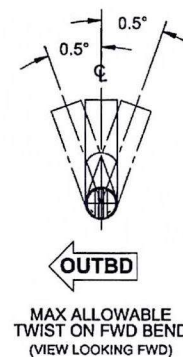
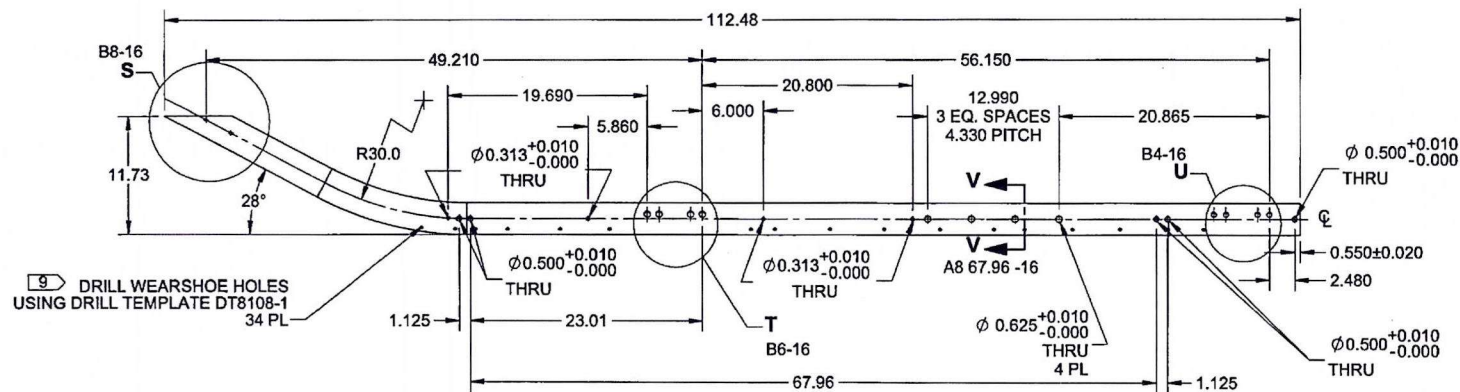


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SECTION R-R
SCALE 4X, 4 PL

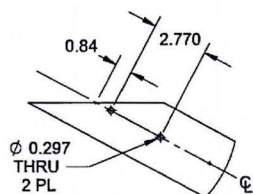
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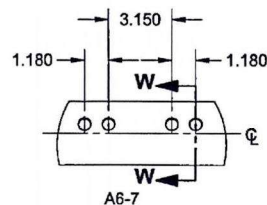
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MFG. APPR.	DD	D2750	SHEET 6 OF 16
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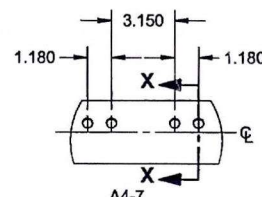
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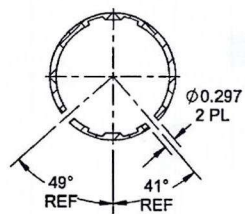
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DETAIL S
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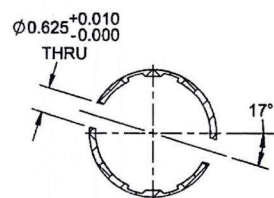
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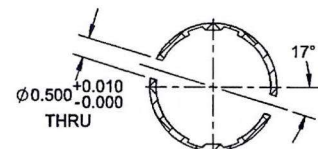
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DETAIL U
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D4-7
SECTION V-V
SCALE 4X, 17 PL



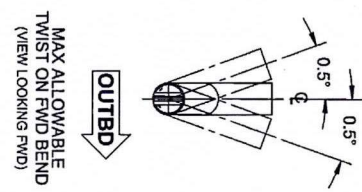
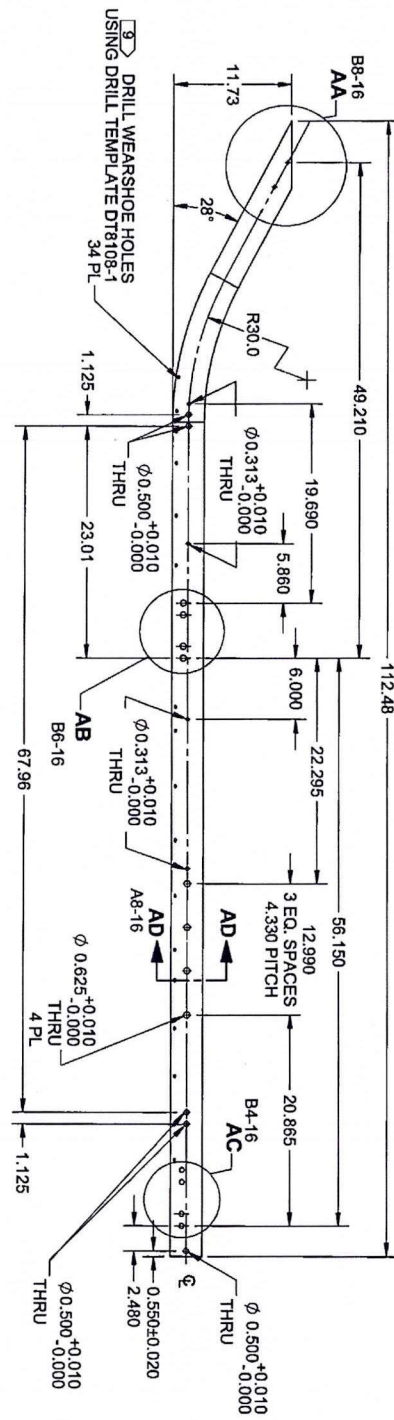
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SECTION W-W
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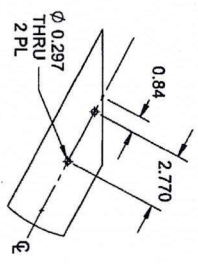
B4-7
SECTION X-X
SCALE 4X, 4 PL

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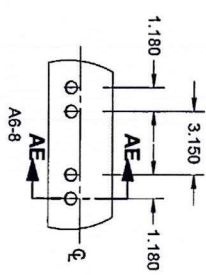
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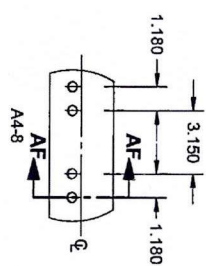
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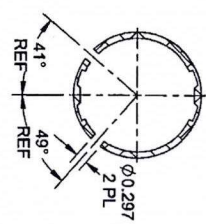
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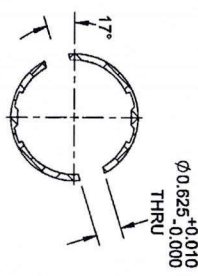
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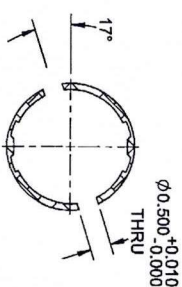
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SECTION AD-AD
SCALE 4X, 17 PL



SECTION AE-AE
SCALE 4X, 4 PL

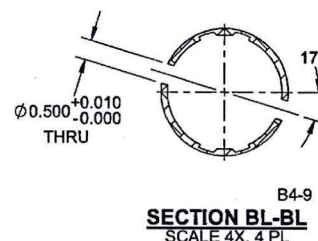
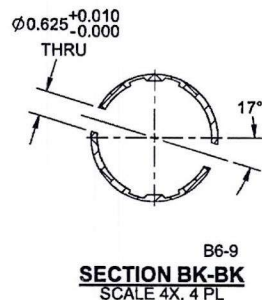
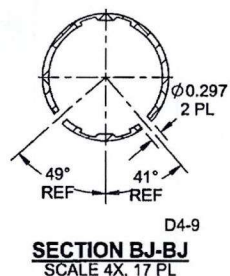
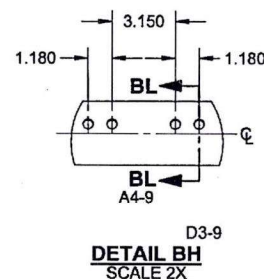
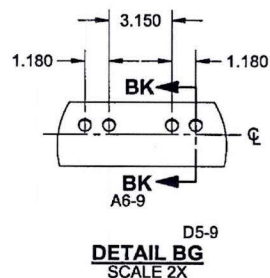
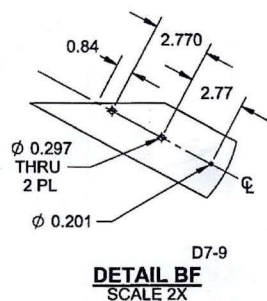
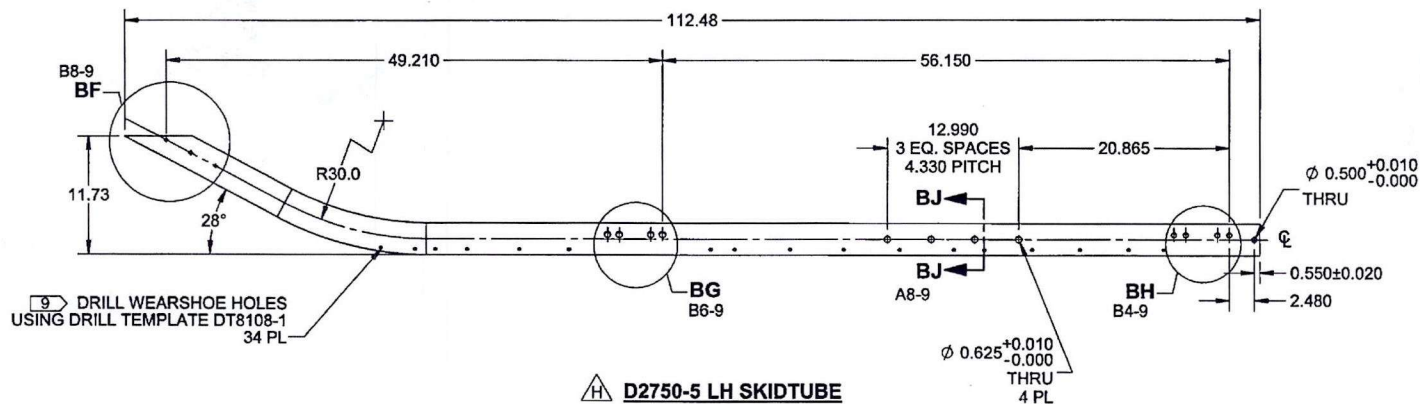


SECTION AF-AF
SCALE 4X, 4 PL

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TITLE	350 SKIDTUBE ASSEMBLY	
REV. H	SHEET 8 OF 16	
SCALE	NTS	

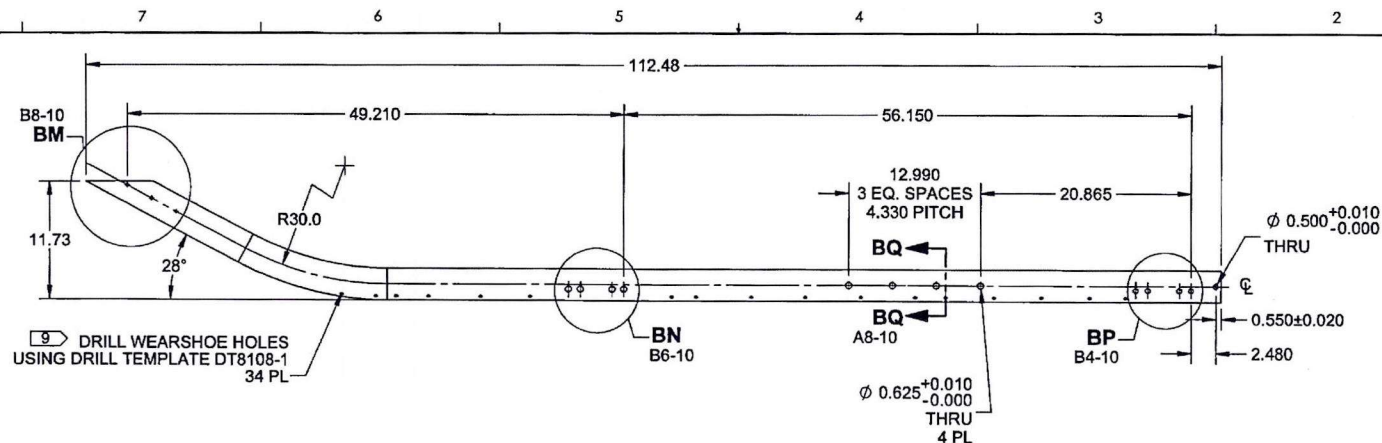
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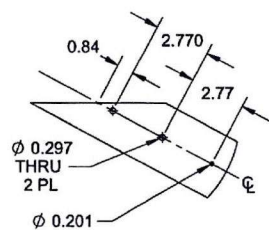
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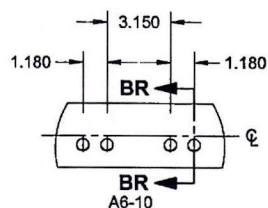
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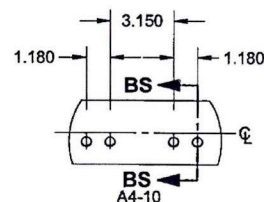
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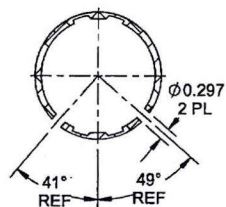
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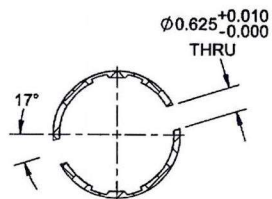
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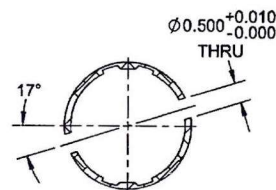
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SECTION BQ-BQ
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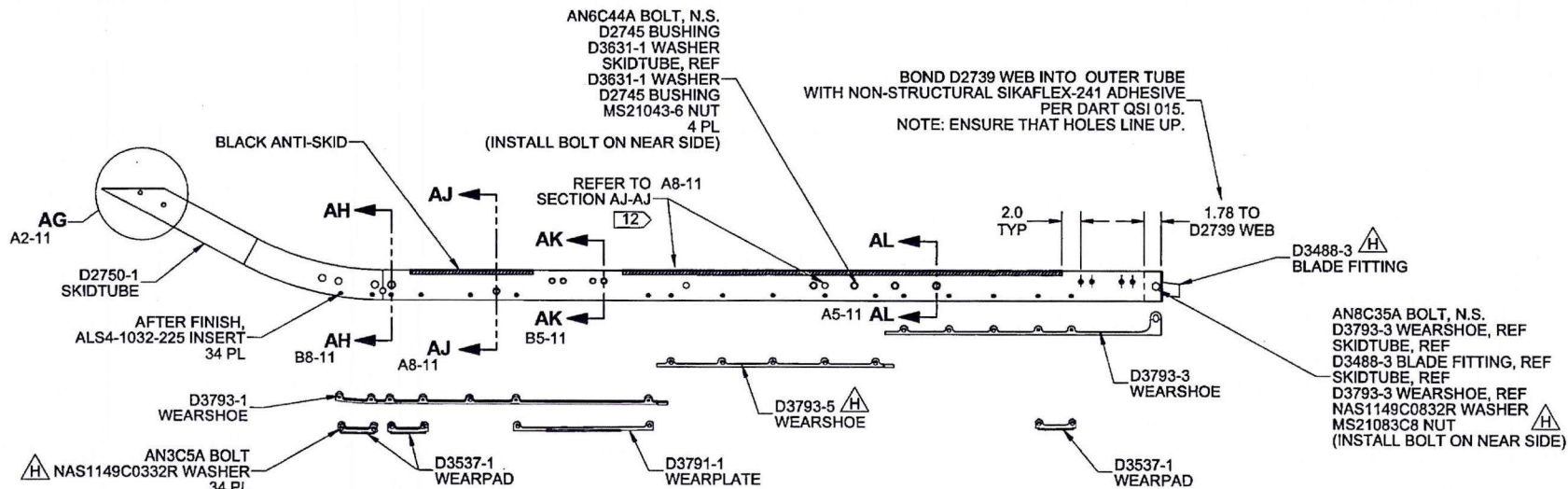
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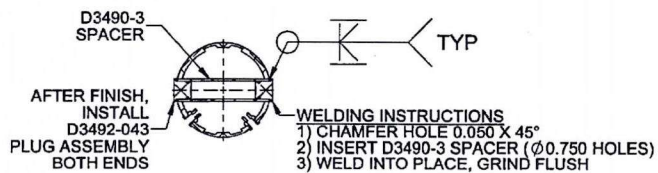
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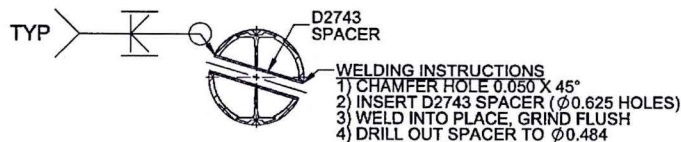
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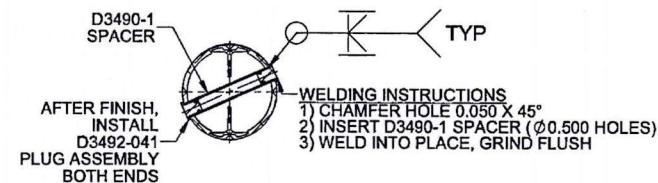
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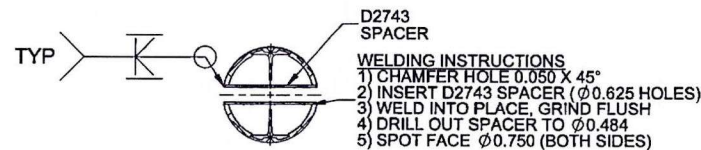
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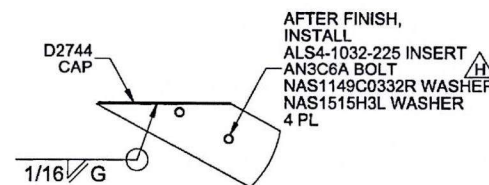
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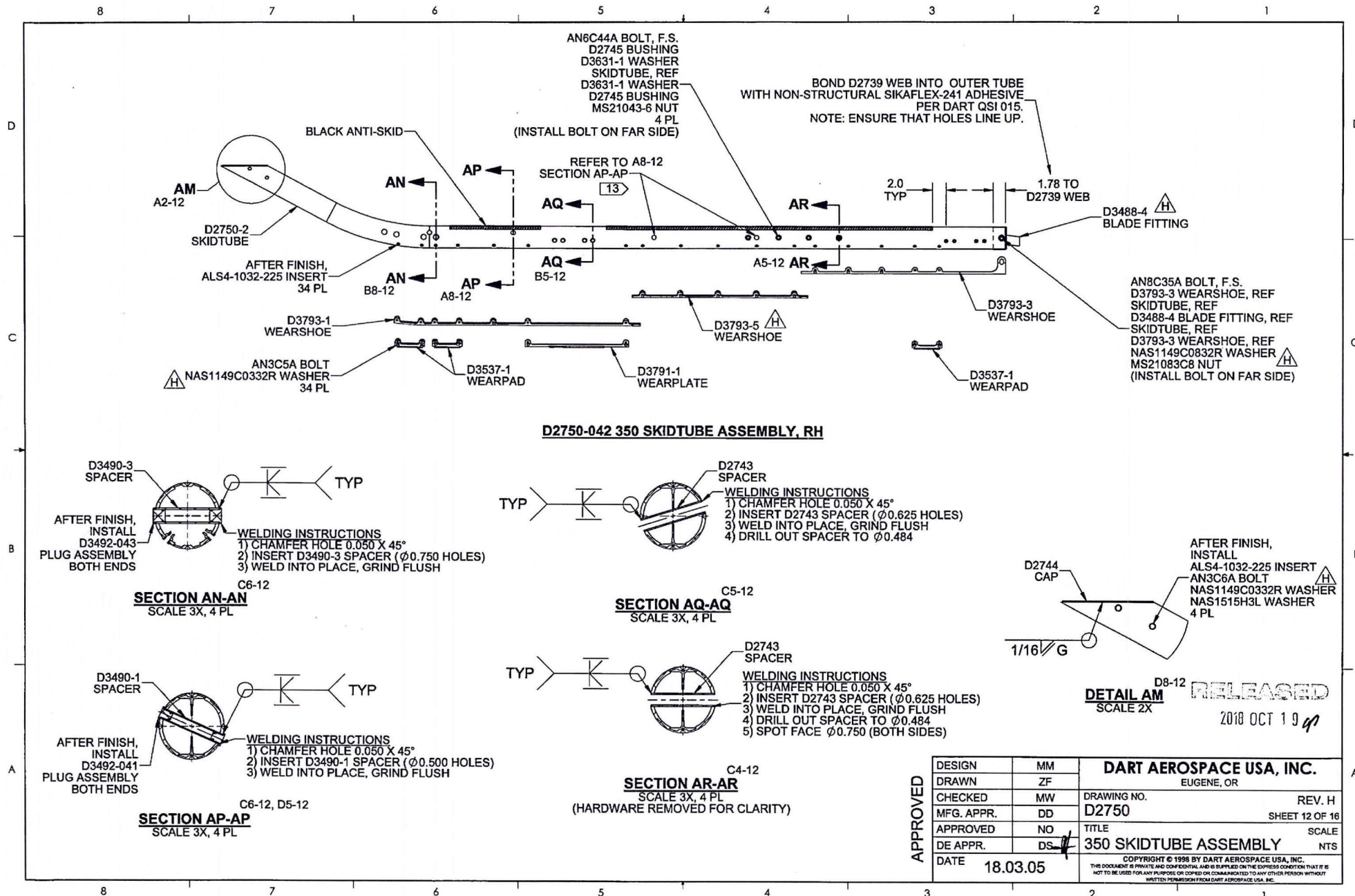
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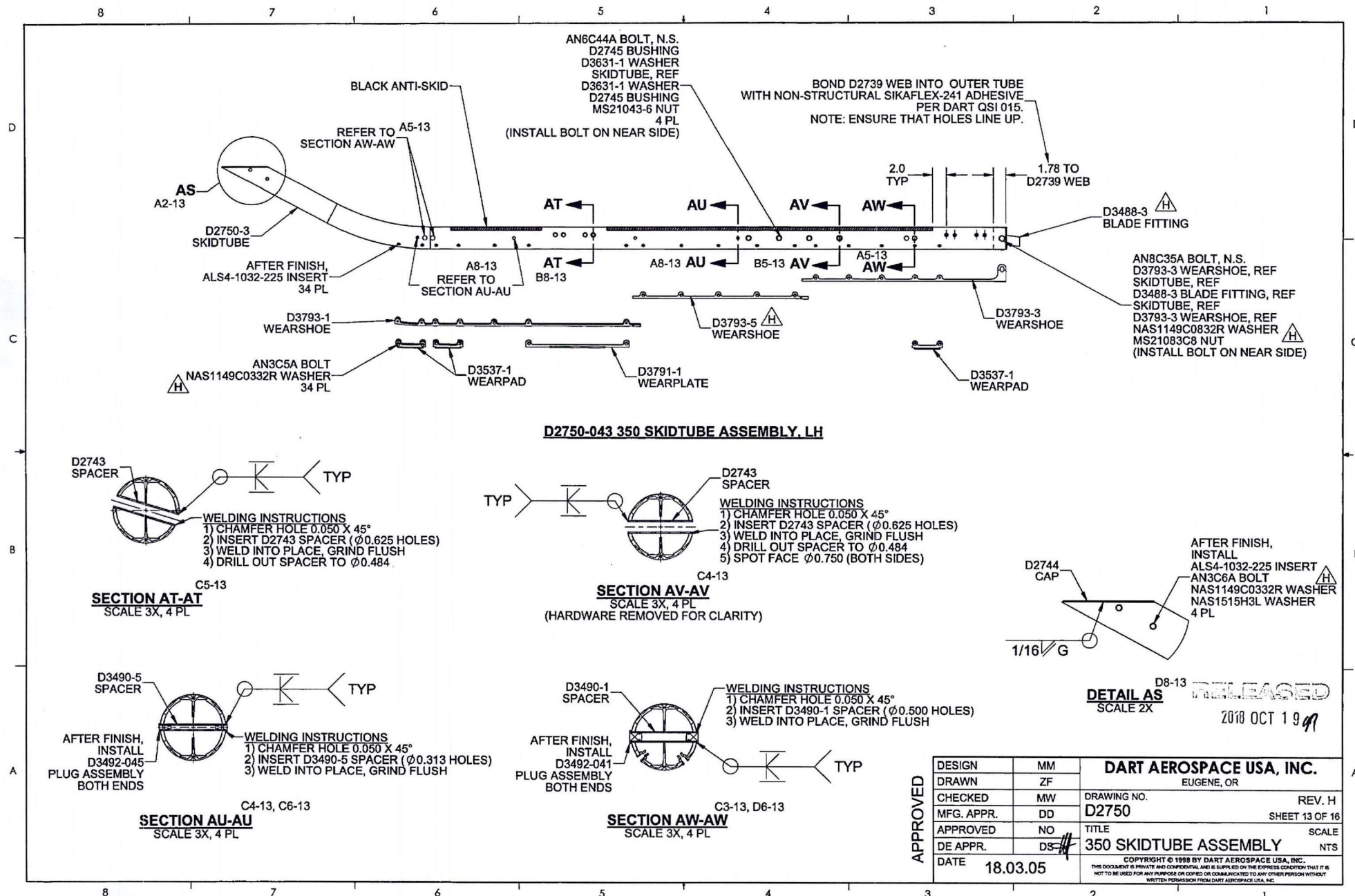


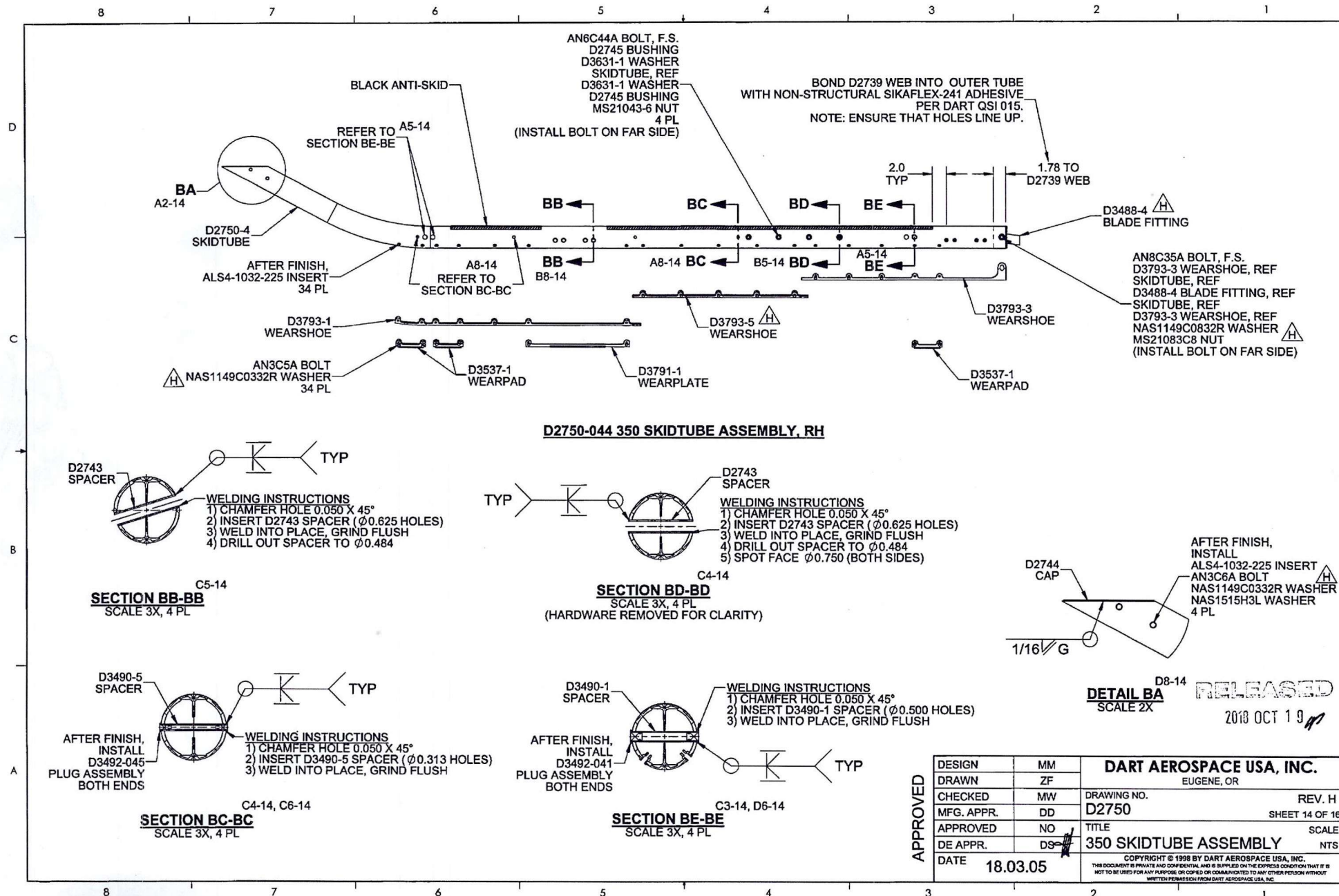
DETAIL AG SCALE 2X

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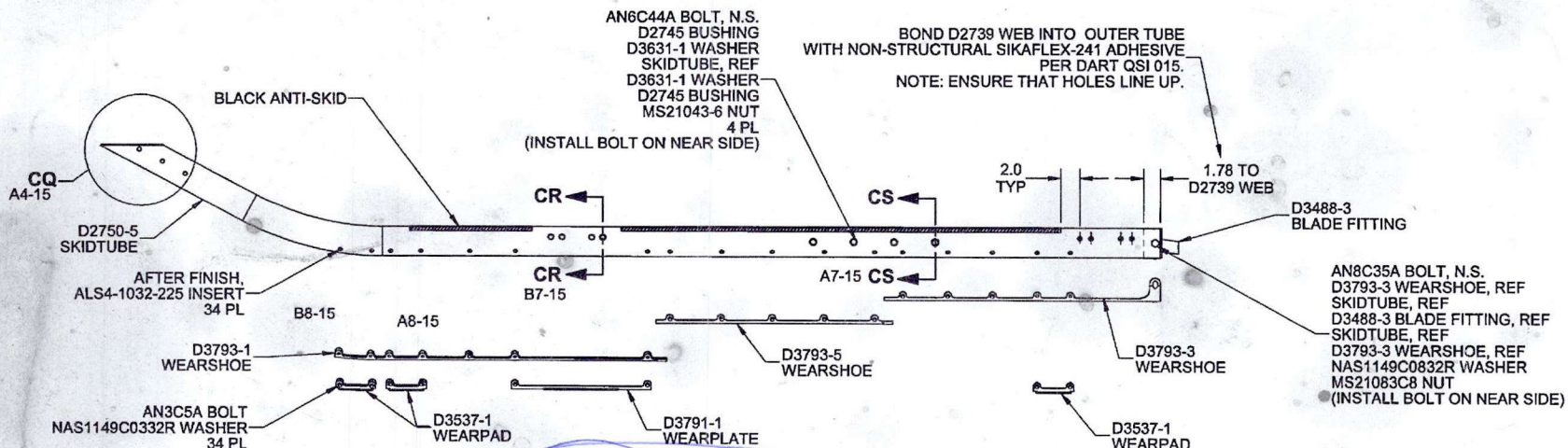
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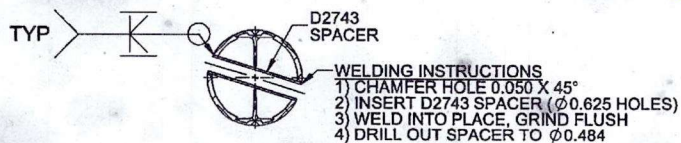




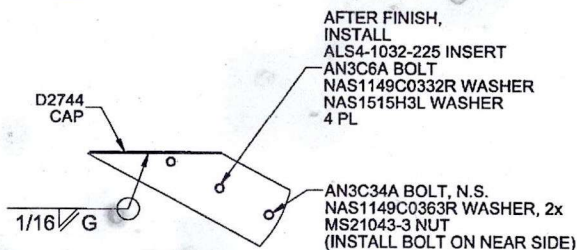
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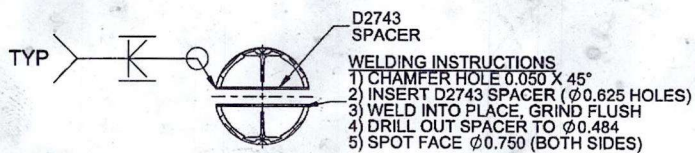
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SECTION CR-CR
SCALE 3X, 4 PL



DETAIL CQ
SCALE 2X



SECTION CS-CS
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

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8 7 6 5 4 3 2 1

S175694 x1 xLH

DART
AEROSPACE

Container No: S175694



Part: D350-636-021

Job No: 194007

Serial No/Batch: S175694

Revision: H/K

Inspector:

Exp Date:

Instructions: FAA STC SR00646SE 18/10/17, TC STC SH99-7 Issue 2, EASA ST

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Hawkesbury, ON K6A 1K7
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